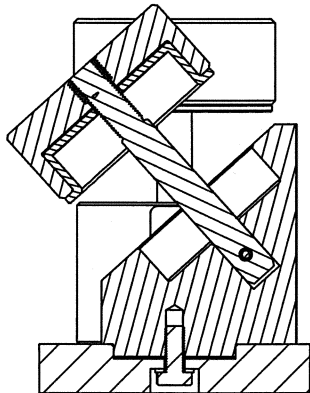
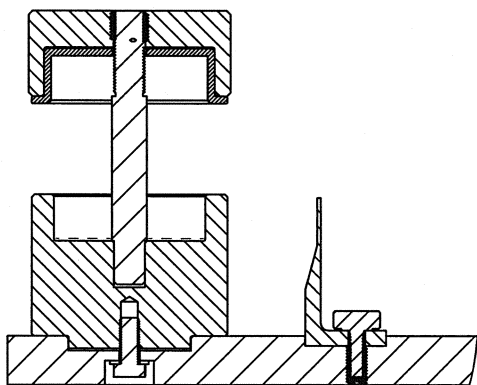
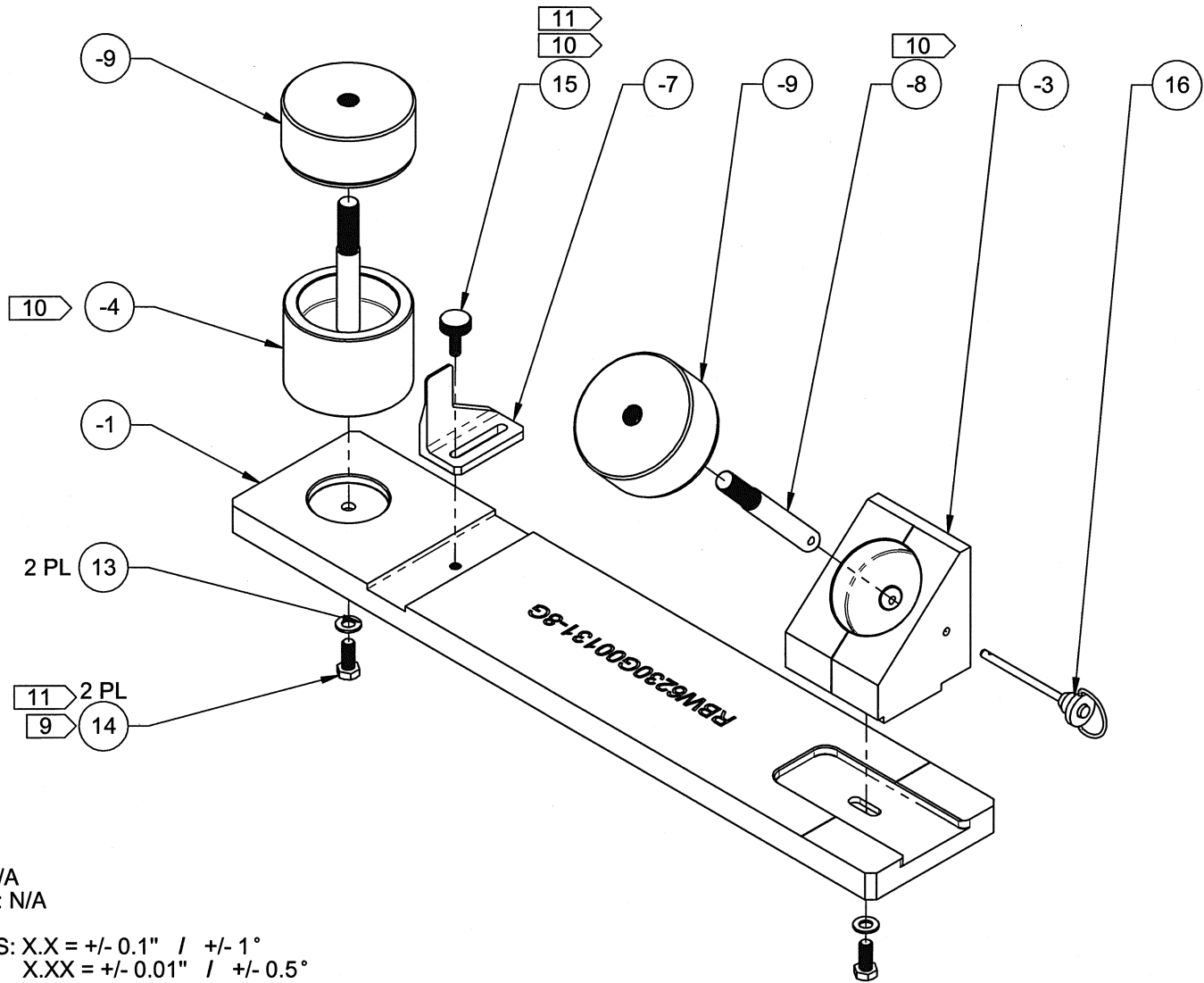


ITEM #	QTY	PART #	PART TITLE
-1	1	RBW6230G00131-8G-1	BASE ASSY
-3	1	RBW6230G00131-8G-3	SUPPORT 1
-4	1	RBW6230G00131-8G-4	SUPPORT 2 ASSY
-7	1	RBW6230G00131-8G-7	STOPPER
-8	1	RBW6230G00131-8G-8	ALIGNMENT PIN
-9	2	RBW6230G00131-8G-9	CAP FINAL ASSY
13	2	McMaster#91525A229 OR EQUIV	SS FLAT WASHER FOR 5/16" SCREW
14	2	McMaster#93190A340 OR EQUIV	SS HEX HEAD SCREW 5/16"-24 x 3/4" LG.
15	1	McMaster#91185A406 OR EQUIV	PLASTIC HEAD THUMB SCREW 1/4"-20 THREAD SS x 3/4" LG.
16	1	McMaster#92384A021 OR EQUIV	SS QUICK RELEASE PIN 3/16" DIA. x 2-1/2" USABLE LENGTH

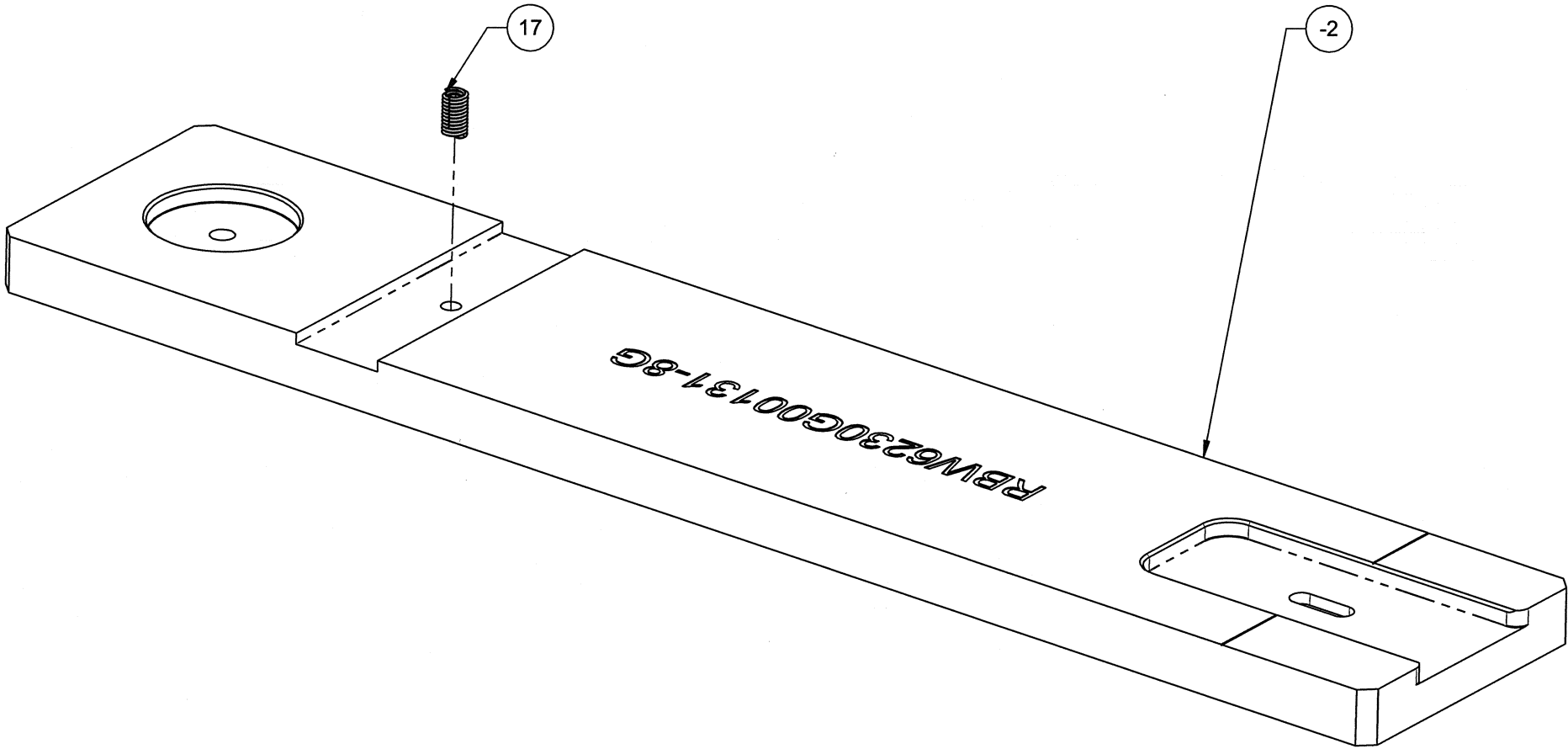


RBW6230G00131-8G MAIN ROTOR PITCH CONTROL LINK ADJUSTMENT TOOL

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) ASSEMBLE AS SHOWN
 - 9) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEMS 14 THEN ASSEMBLE WITH ITEM -1, -3 AND -4 AND REMOVE EXCESS
 - 10) APPLY LOCTITE NICKEL BASED ANTI SEIZE ON EXTERNAL THREADS OF ITEM -4, ITEM -8 AND ITEM 15 THEN ASSEMBLE WITH ITEMS -1 AND -9 AND REMOVE EXCESS
 - 11) INSTALL ITEMS 14 AND 15 HAND TIGHT
 - 12) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

A	NEW ISSUE	19-557	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	PK	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6230G00131-8G	SHEET 1 OF 13
APPROVED	WY	TITLE	SCALE
		MAIN ROTOR PITCH CONTROL LINK ADJUSTMENT TOOL	NTS
DATE	2/4/2019	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

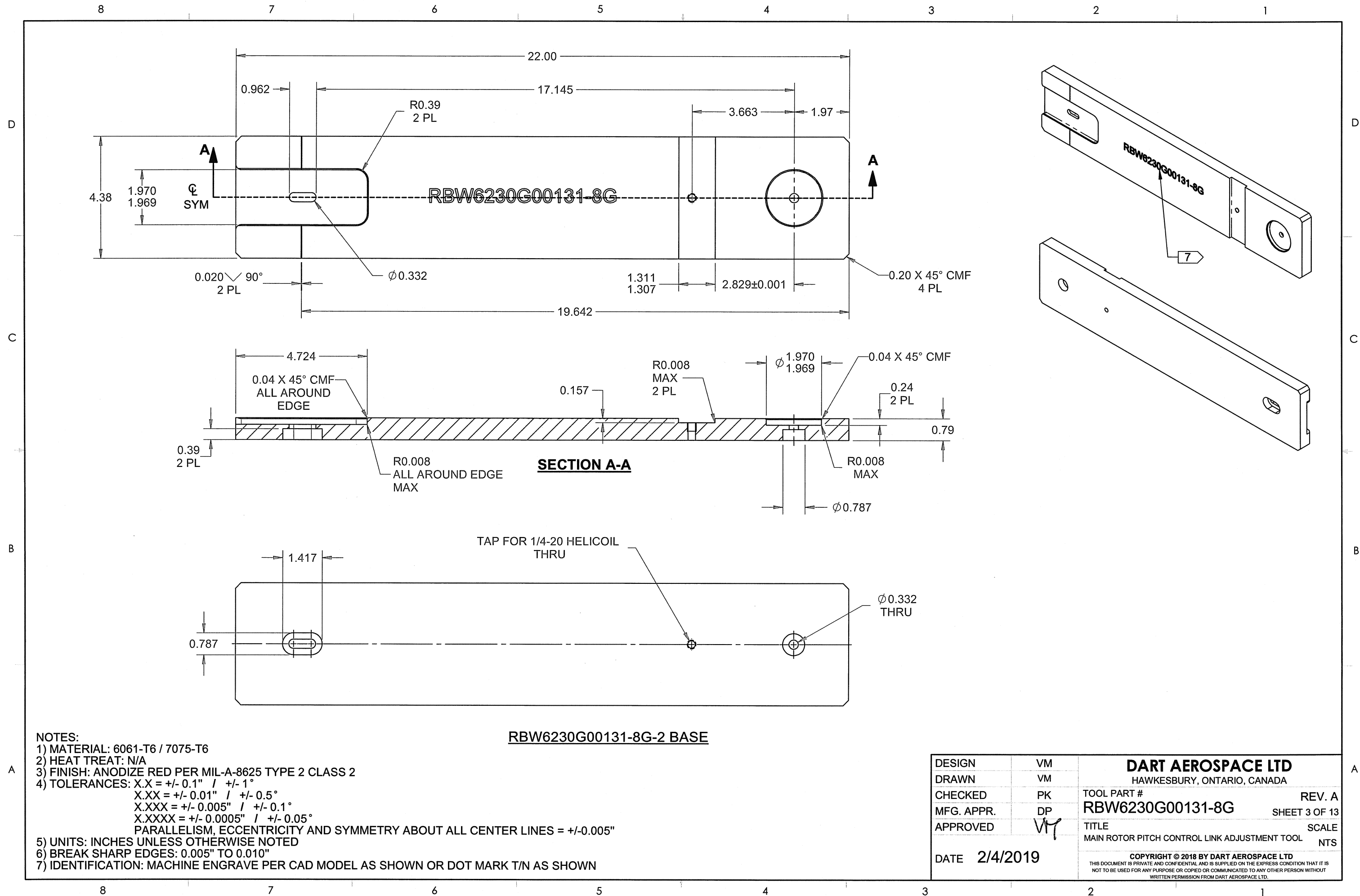
ITEM #	QTY	PART #	PART TITLE
-2	1	RBW6230G00131-8G-2	BASE
17	1	McMaster#91732A735 OR EQUIV	SS HELICAL INSERT 1/4"-20 x 5/8" LG.



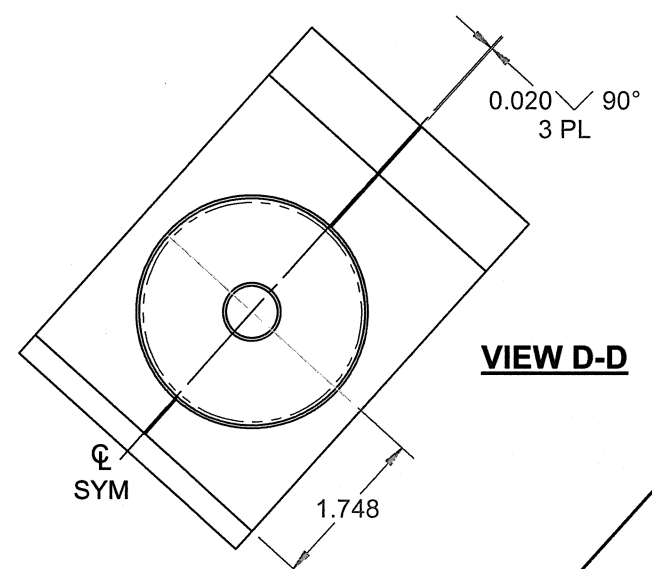
RBW6230G00131-8G-1 BASE ASSY

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A
8) ASSEMBLE AS SHOWN

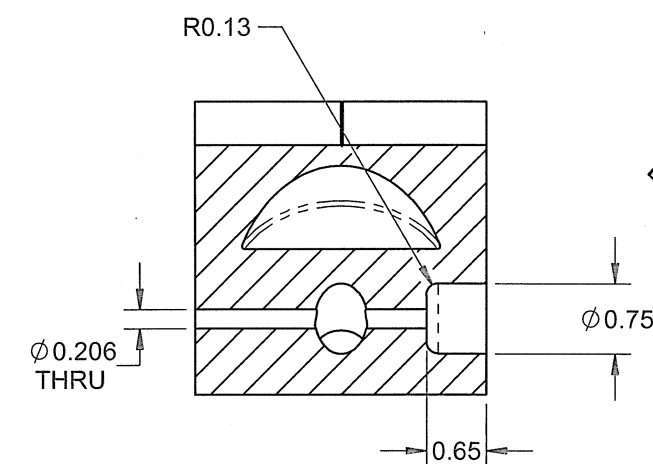
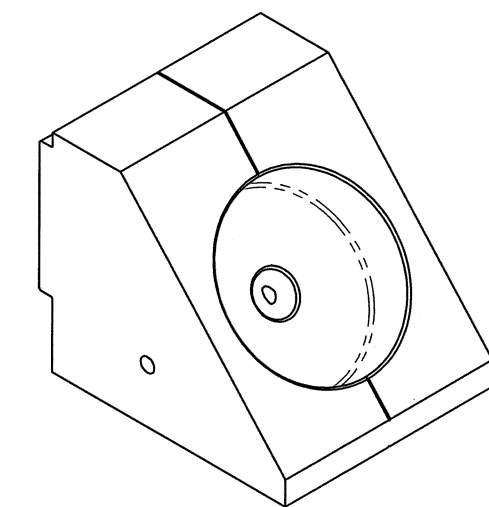
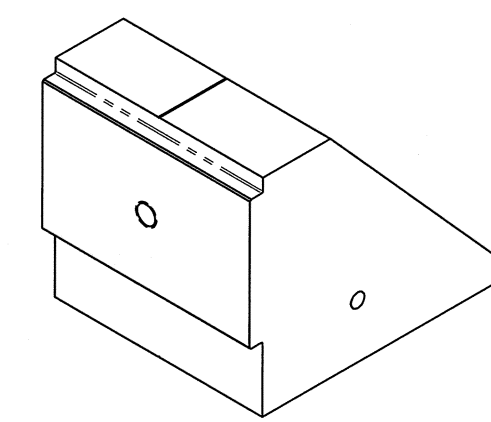
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	PK	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6230G00131-8G	SHEET 2 OF 13
APPROVED	Wp	TITLE	SCALE
DATE 2/4/2019		MAIN ROTOR PITCH CONTROL LINK ADJUSTMENT TOOL	NTS
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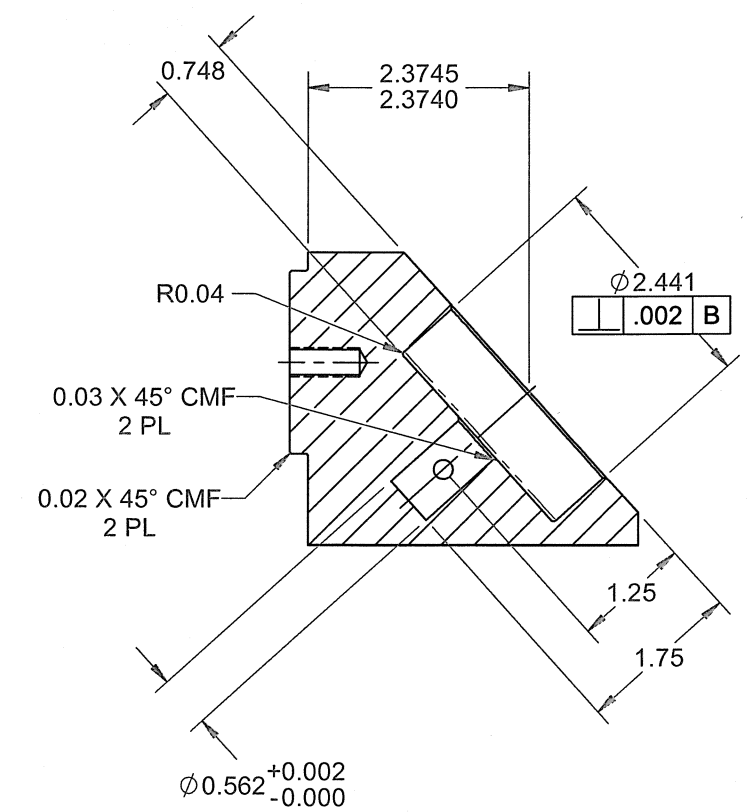
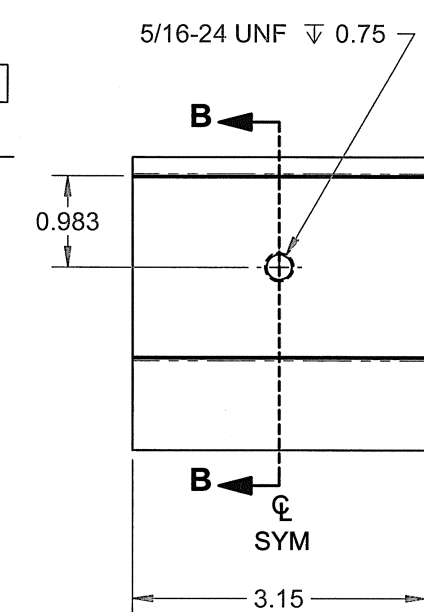
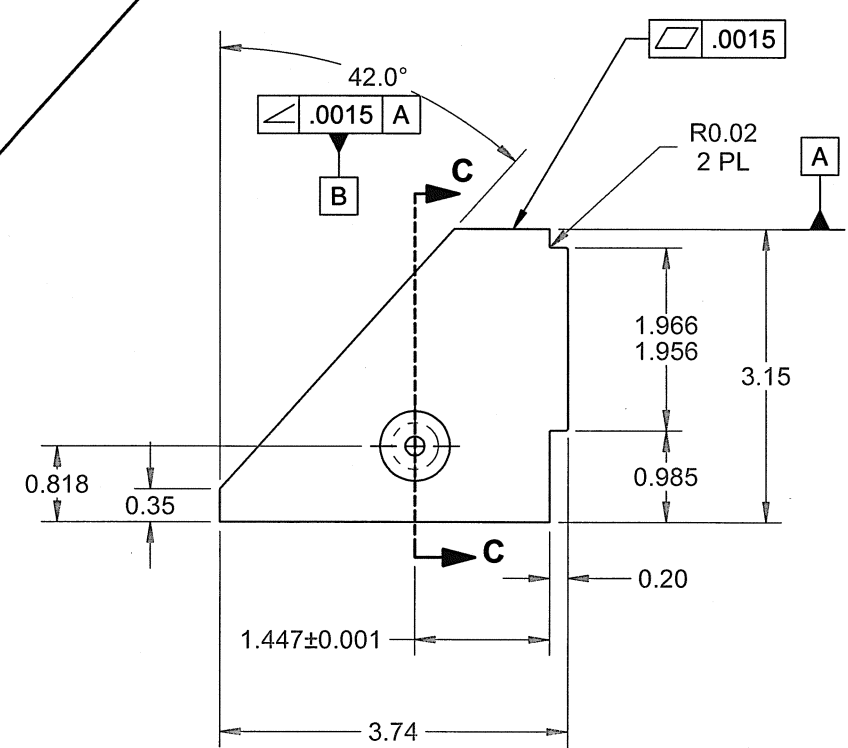
8 7 6 5 4 3 2 1



VIEW D-D



SECTION C-C



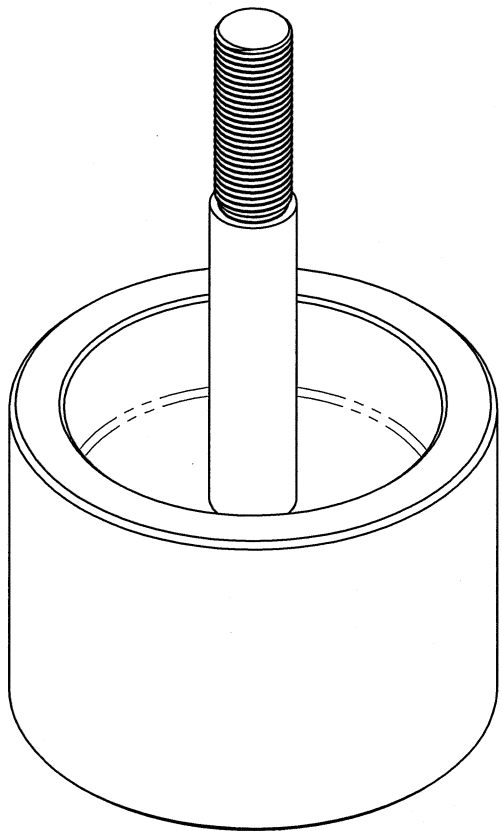
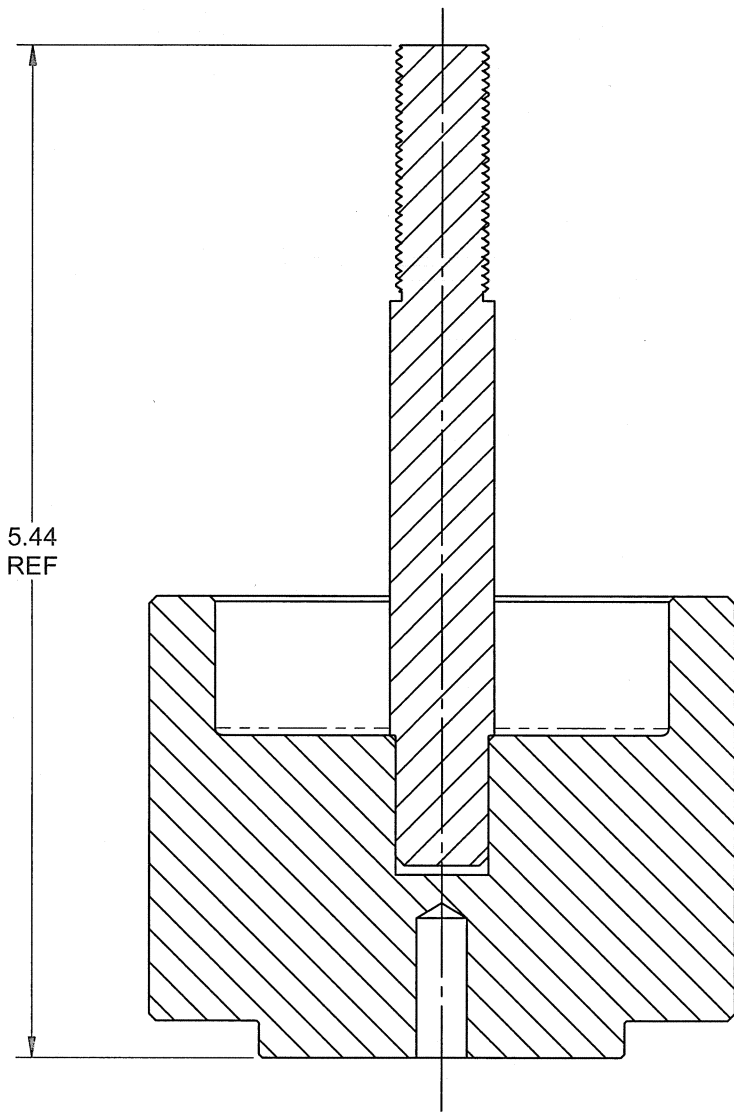
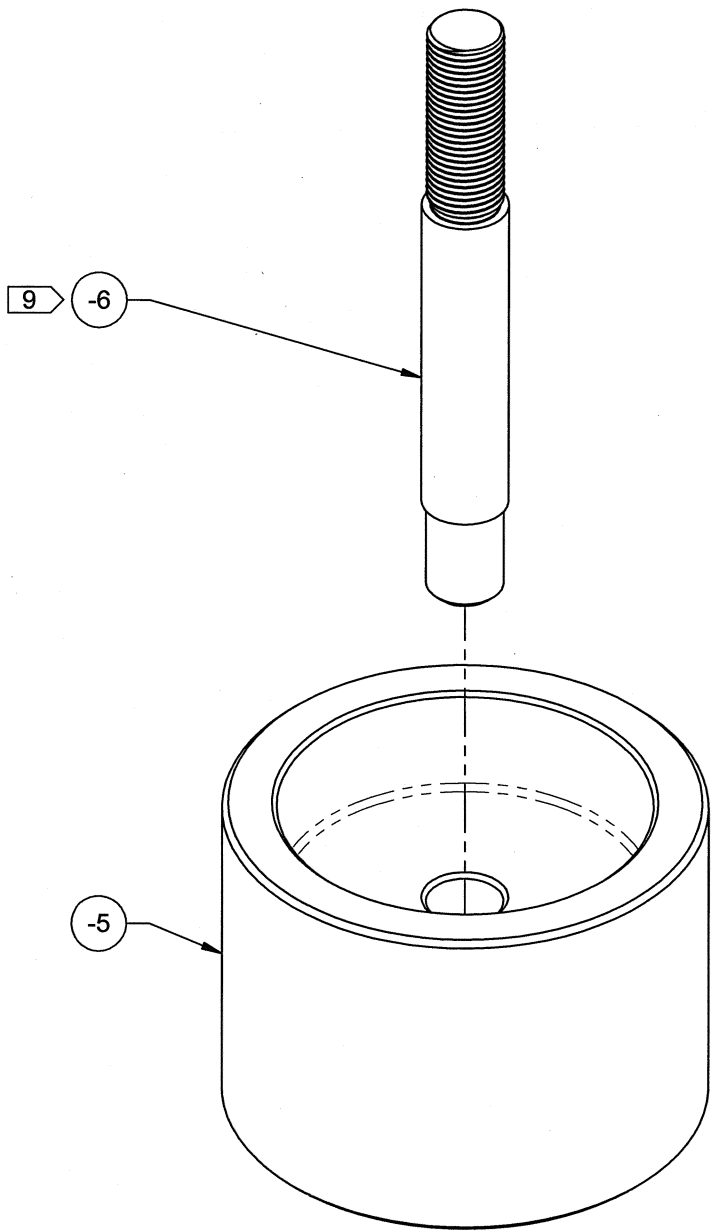
SECTION B-B

RBW6230G00131-8G-3 SUPPORT 1

- NOTES:
- 1) MATERIAL: 303/304/316 STAINLESS STEEL
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	PK	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6230G00131-8G	SHEET 4 OF 13
APPROVED	W	TITLE	SCALE
		MAIN ROTOR PITCH CONTROL LINK ADJUSTMENT TOOL	NTS
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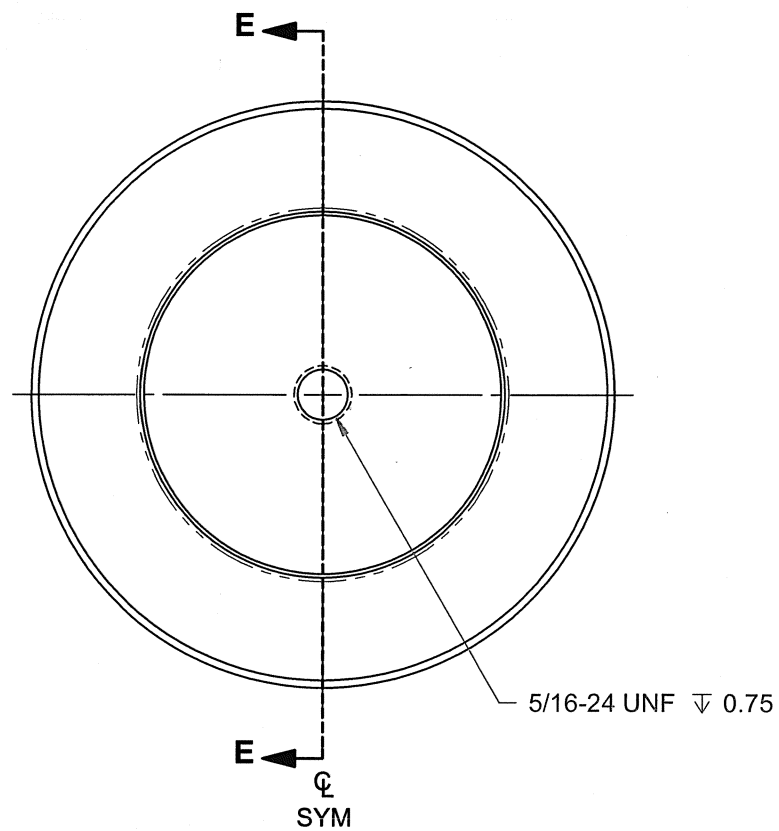
ITEM #	QTY	PART #	PART TITLE
-5	1	RBW6230G00131-8G-5	SUPPORT BASE 2
-6	1	RBW6230G00131-8G-6	PIN SUPPORT 2



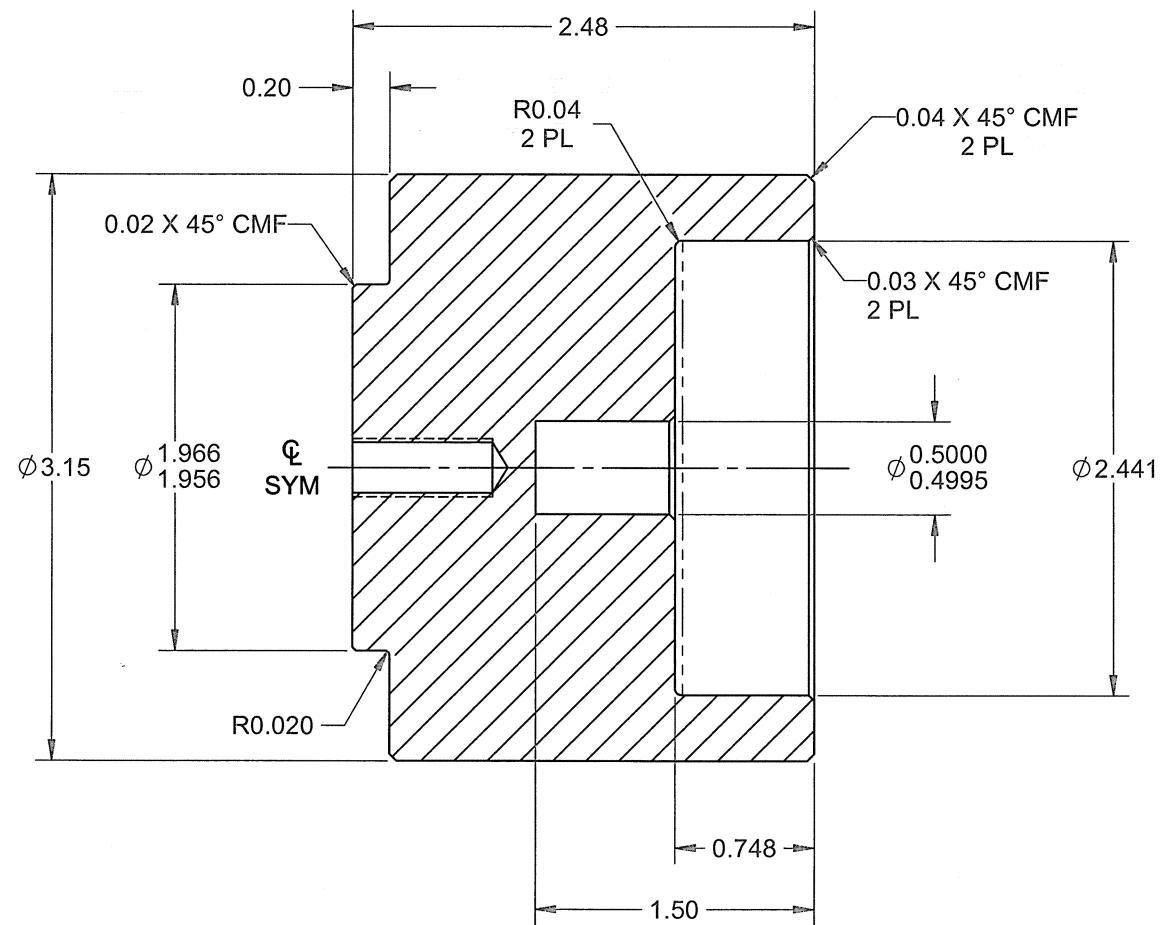
RBW6230G00131-8G-4 SUPPORT 2 ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) ASSEMBLE AS SHOWN
 - 9) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEM -6 WITH ITEM -5 AND REMOVE EXCESS

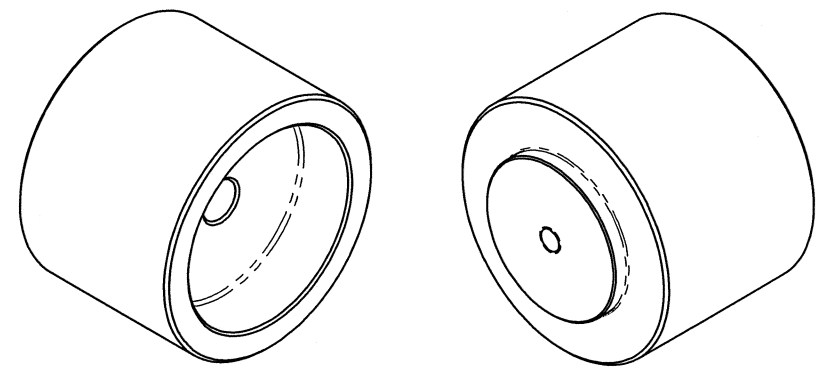
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	PK	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6230G00131-8G	SHEET 5 OF 13
APPROVED	VHP	TITLE	SCALE
DATE 2/4/2019		MAIN ROTOR PITCH CONTROL LINK ADJUSTMENT TOOL	NTS
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RBW6230G00131-8G-5 SUPPORT BASE 2



SECTION E-E



NOTES:

1) MATERIAL: 303/304/316 STAINLESS STEEL

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

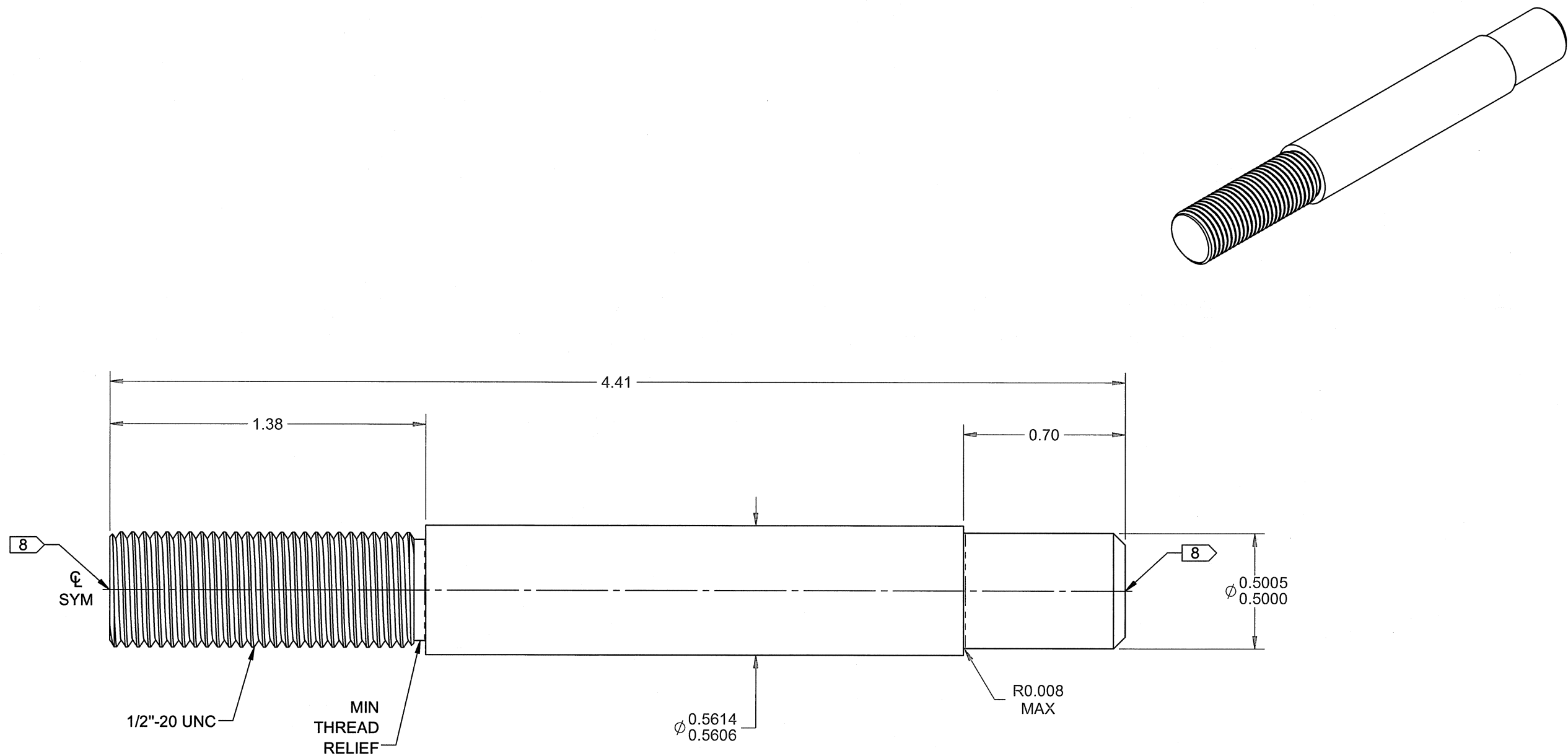
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005" TO 0.010"

7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	PK	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6230G00131-8G	SHEET 6 OF 13
APPROVED	<i>WY</i>	TITLE	SCALE
DATE 2/4/2019		MAIN ROTOR PITCH CONTROL LINK ADJUSTMENT TOOL	NTS
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RBW6230G00131-8G-6 PIN SUPPORT 2

- NOTES:
- 1) MATERIAL: 303/304/316 STAINLESS STEEL
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: N/A
 - 8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	PK	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6230G00131-8G	SHEET 7 OF 13
APPROVED	VM	TITLE	SCALE
DATE 2/4/2019		MAIN ROTOR PITCH CONTROL LINK ADJUSTMENT TOOL	NTS
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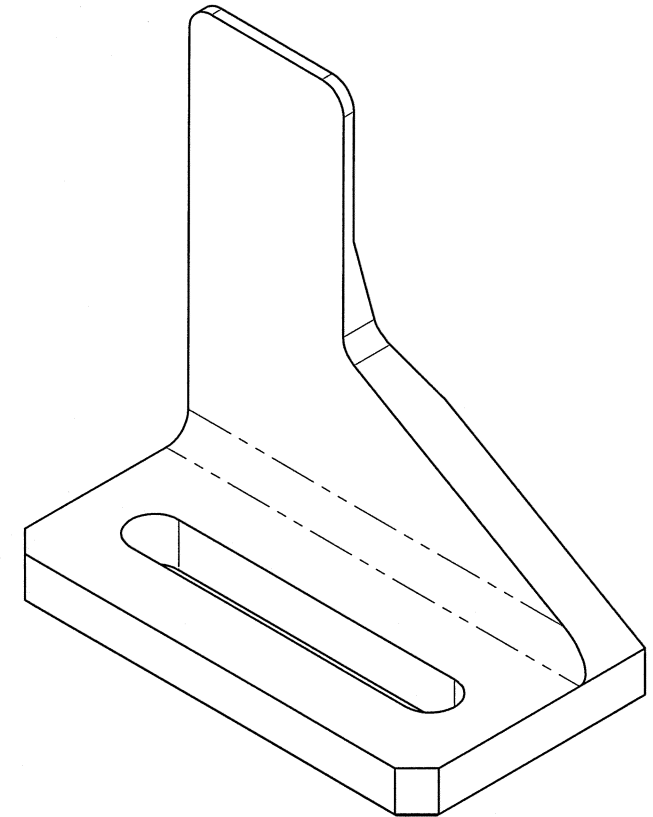
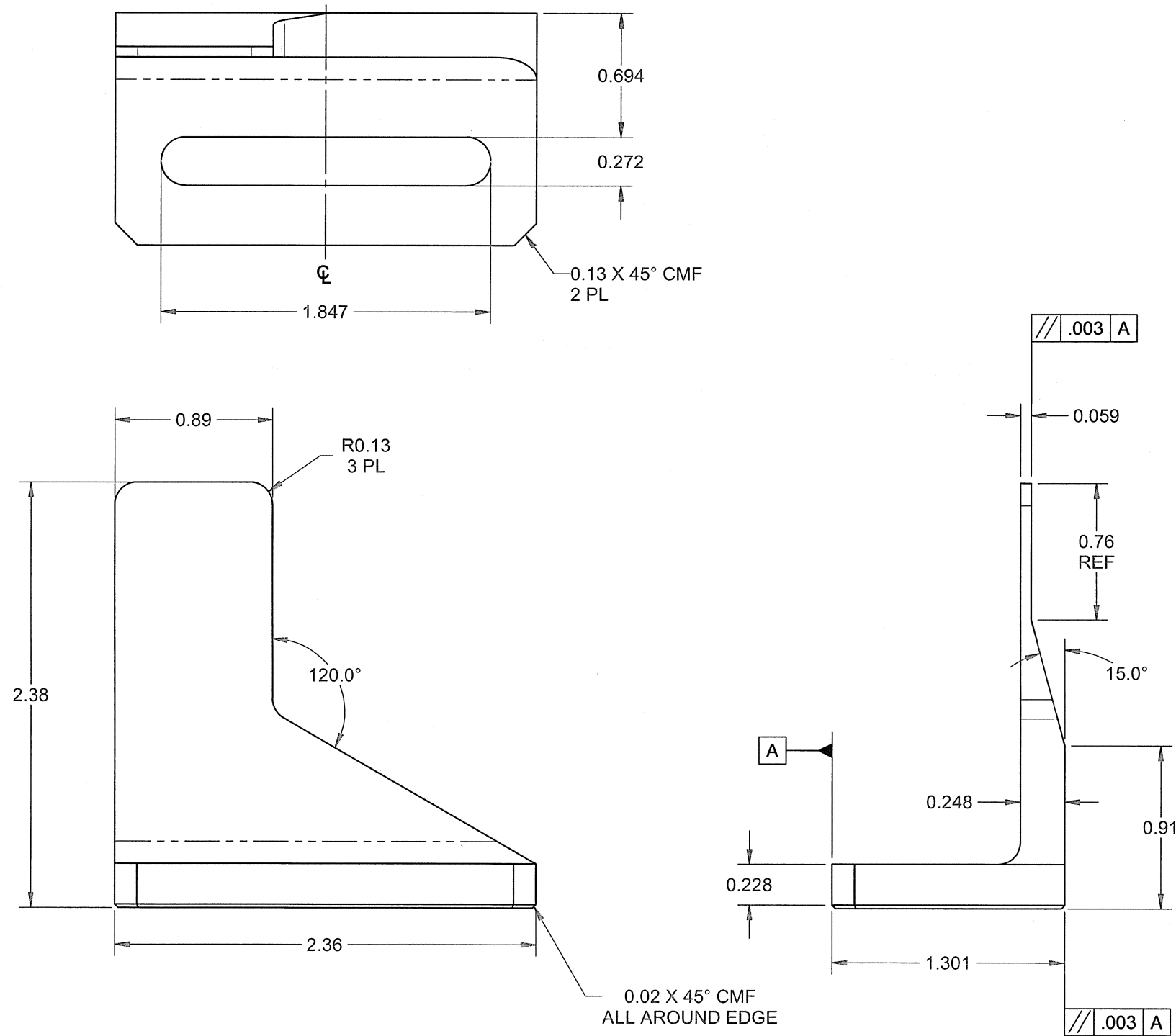
1

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NOTES:

- 1) MATERIAL: McMaster#8993K71 OR EQUIV
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005" TO 0.010"

7) IDENTIFICATION: N/A

RBW6230G00131-8G-7 STOPPER

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PK	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6230G00131-8G	SHEET 8 OF 13
APPROVED	VJP	TITLE	SCALE
		MAIN ROTOR PITCH CONTROL LINK ADJUSTMENT TOOL	NTS
DATE 2/4/2019		COPYRIGHT © 2018 BY DART AEROSPACE LTD	
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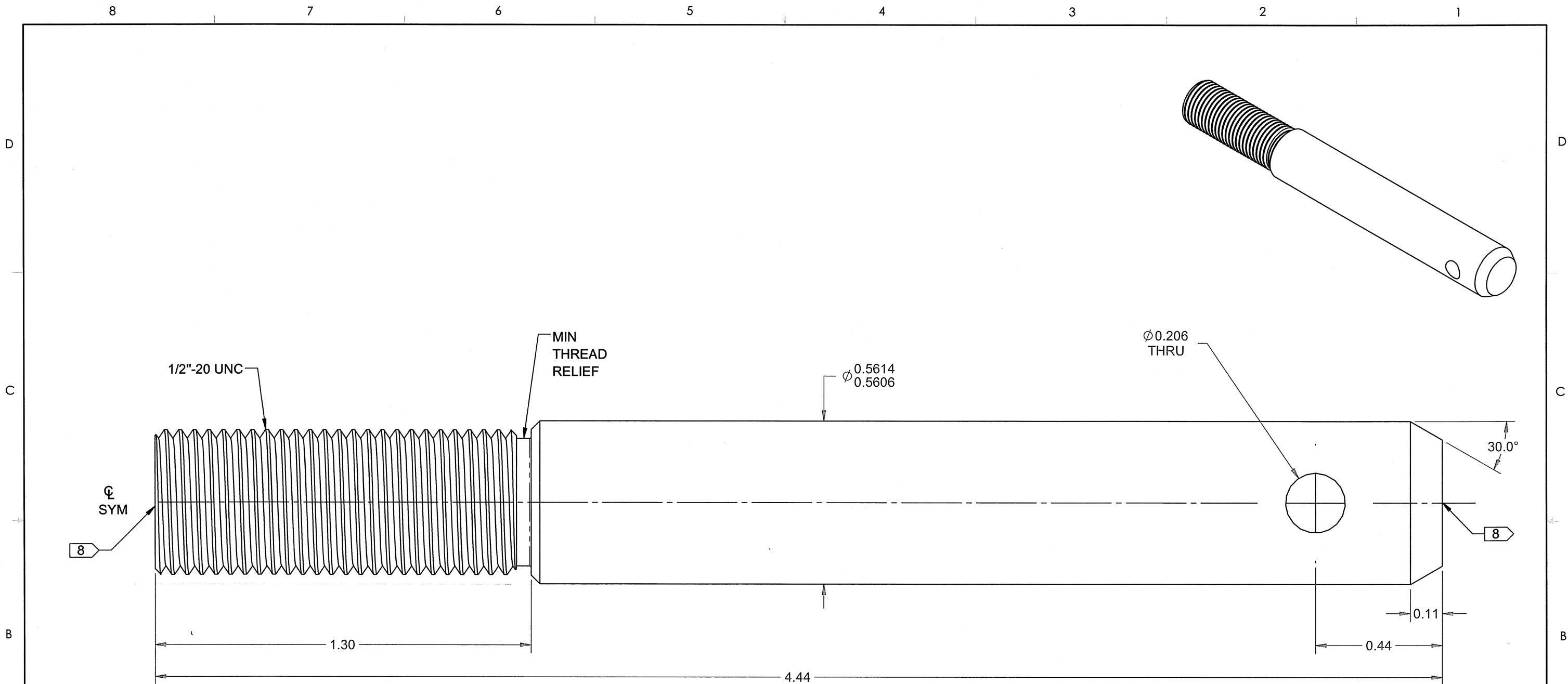
5

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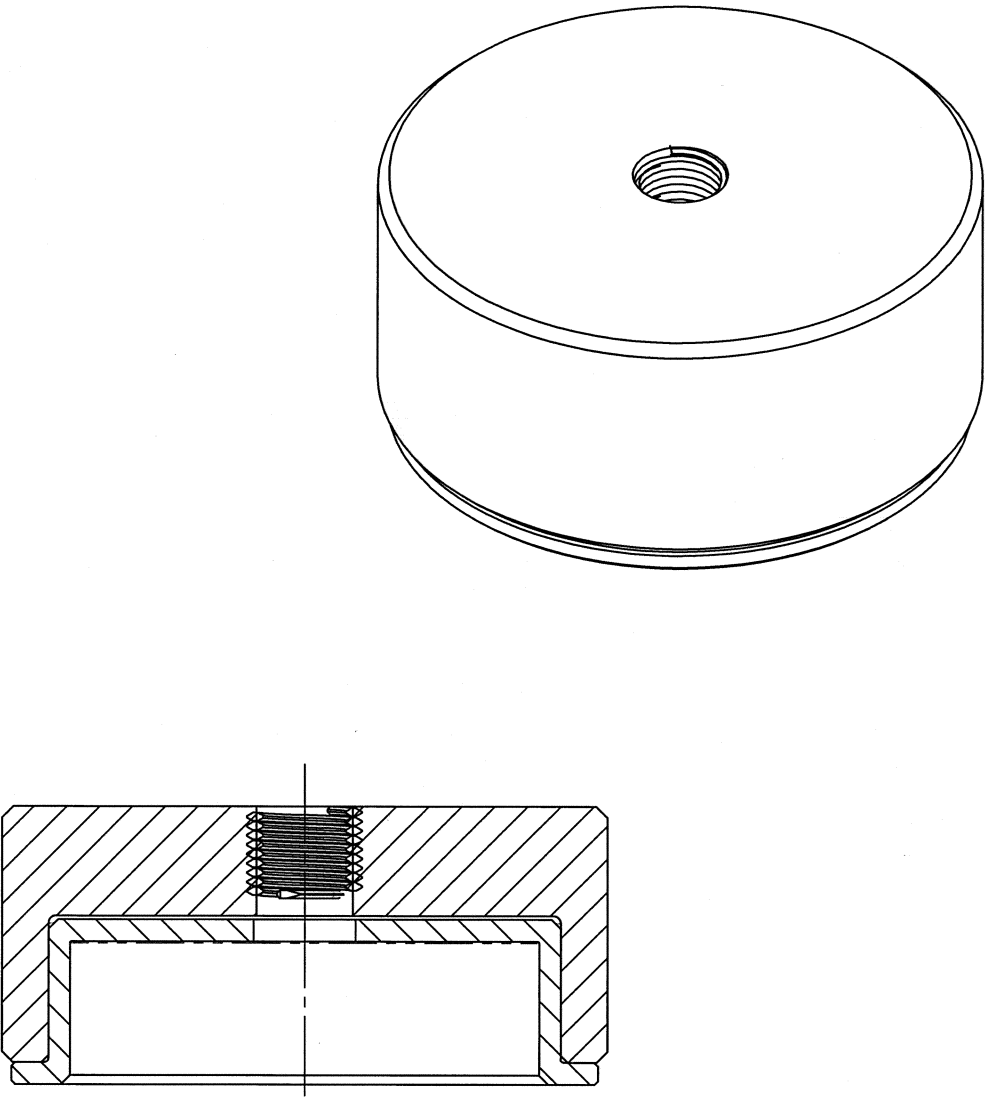
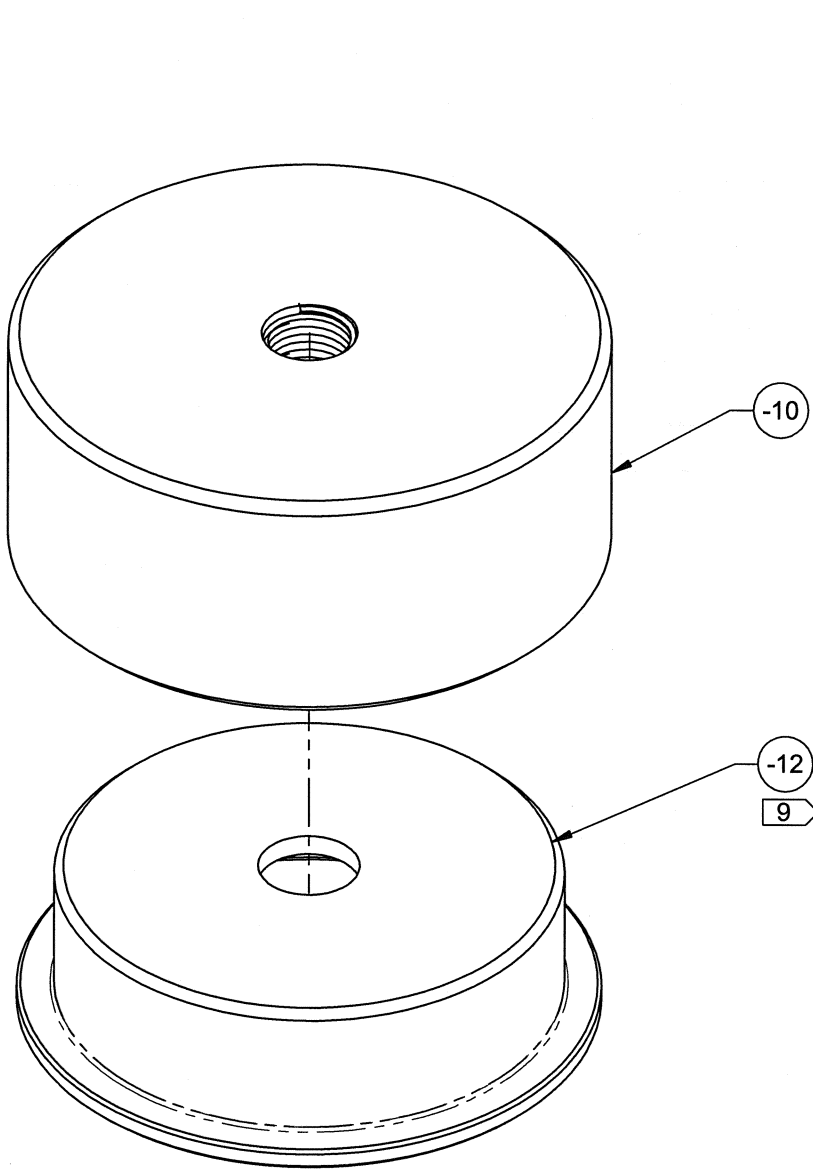


RBW6230G00131-8G-8 ALIGNMENT PIN

- NOTES:
- 1) MATERIAL: 303/304/316 STAINLESS STEEL
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: N/A
 - 8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PK	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6230G00131-8G	SHEET 9 OF 13
APPROVED	VM	TITLE	SCALE
DATE 2/4/2019		MAIN ROTOR PITCH CONTROL LINK ADJUSTMENT TOOL	NTS
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ITEM #	QTY	PART #	PART TITLE
-10	1	RBW6230G00131-8G-10	CAP ASSY
-12	1	RBW6230G00131-8G-12	CAP SLEEVE

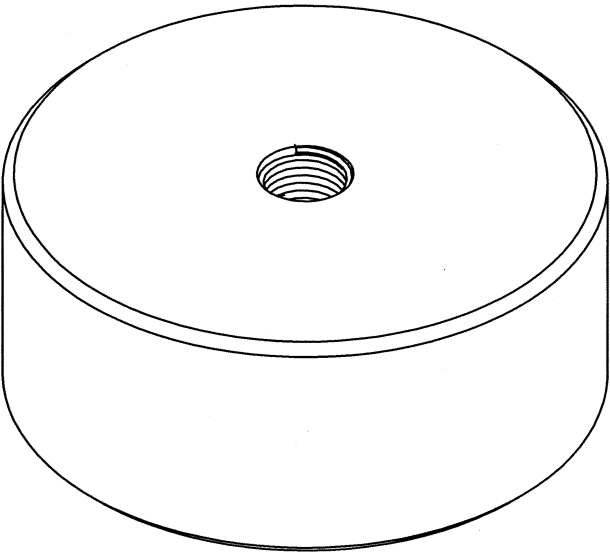
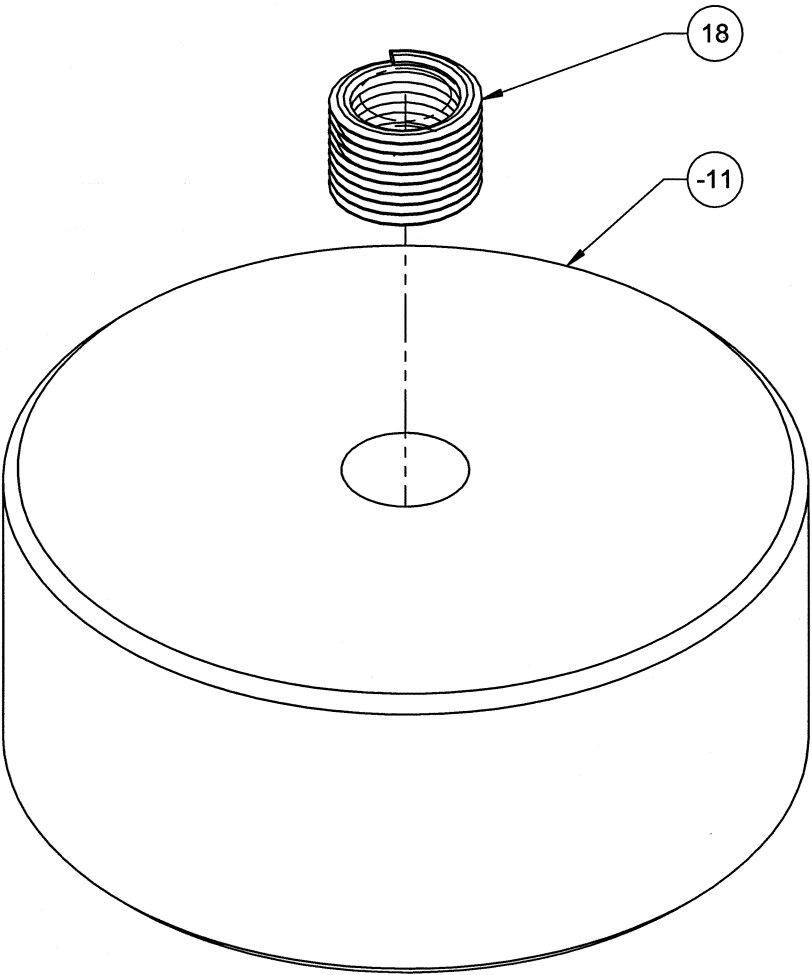


RBW6230G00131-8G-9 CAP FINAL ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) ASSEMBLE AS SHOWN,
 - 9) APPLY CLEAR MULTI PURPOSE LOCTITE ON MATING SURFACES THEN PRESS FIT ITEM -12 WITH ITEM -10 AND REMOVE EXCESS

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	PK	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6230G00131-8G	SHEET 10 OF 13
APPROVED	VM	TITLE	SCALE
DATE 2/4/2019		MAIN ROTOR PITCH CONTROL LINK ADJUSTMENT TOOL	NTS
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ITEM #	QTY	PART #	PART TITLE
-11	1	RBW6230G00131-8G-11	CAP
18	1	McMaster#91732A533 OR EQUIV	HELICAL INSERT STEEL 1/2"-20 x 1/2" LG.

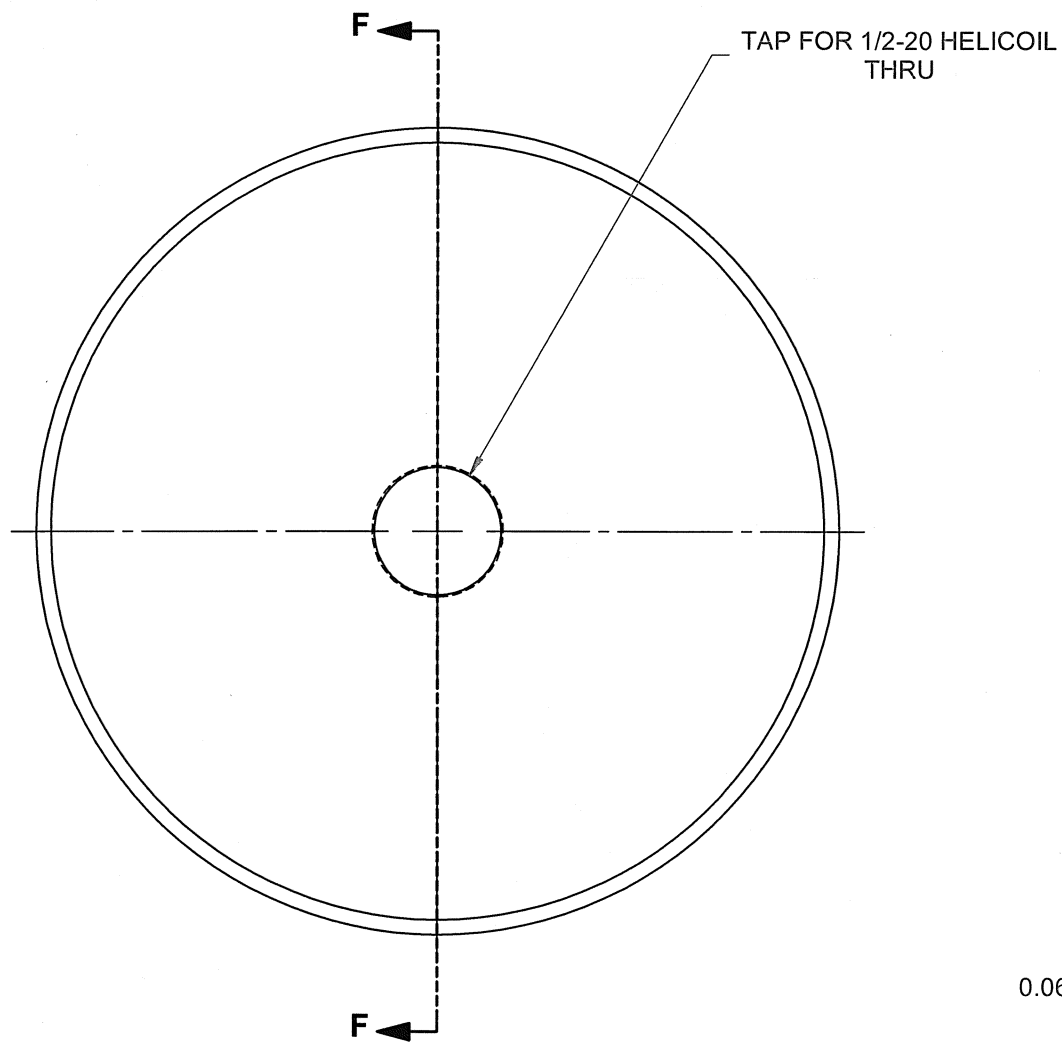


RBW6230G00131-8G-10 CAP ASSY

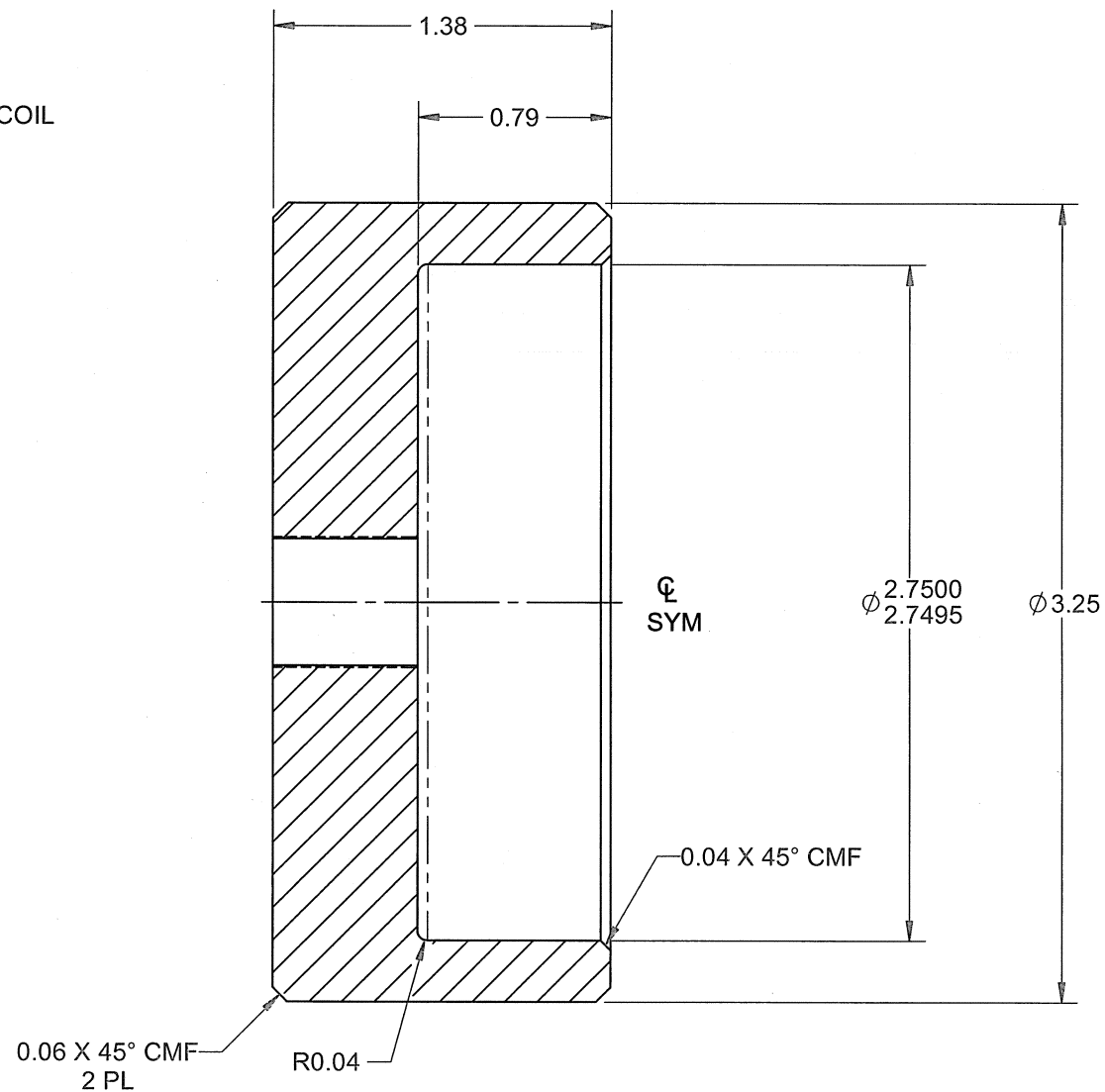
- NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A
8) ASSEMBLE AS SHOWN

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	PK	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6230G00131-8G	SHEET 11 OF 13
APPROVED	WY	TITLE	SCALE
DATE 2/4/2019		MAIN ROTOR PITCH CONTROL LINK ADJUSTMENT TOOL	NTS
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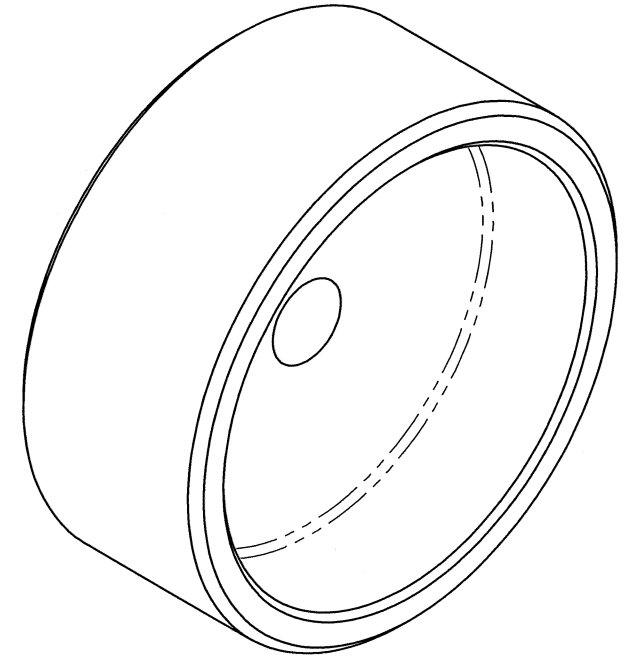
8 7 6 5 4 3 2 1



RBW6230G00131-8G-11 CAP



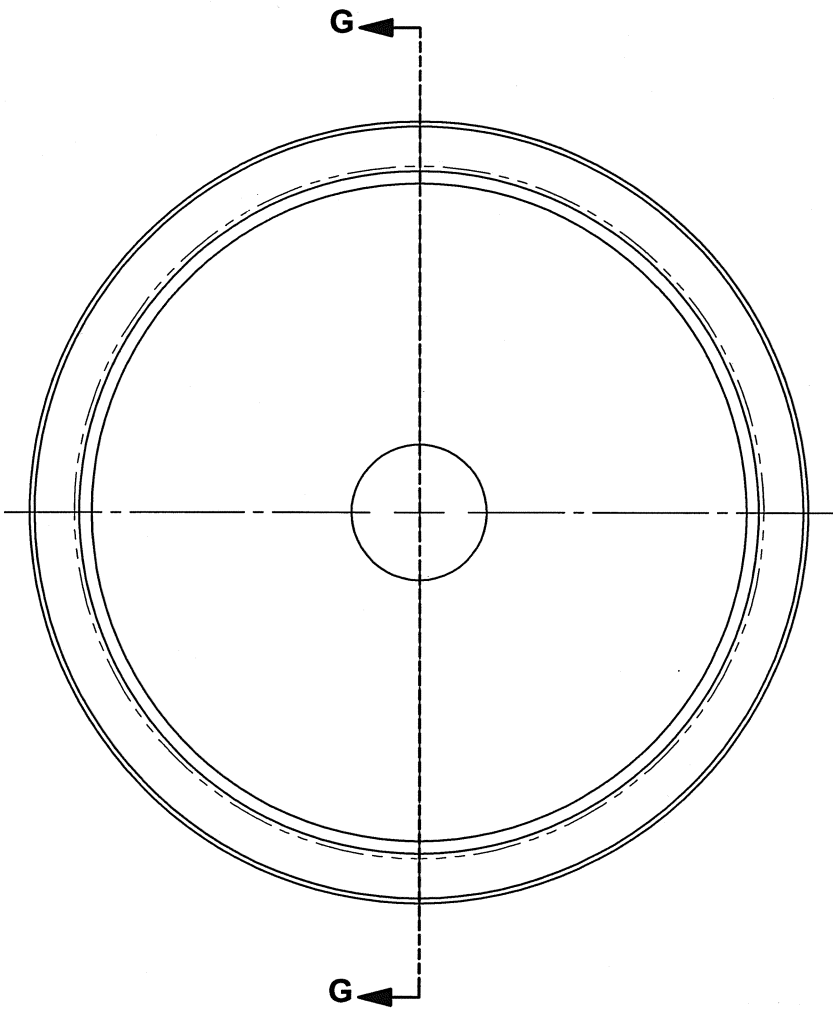
SECTION F-F



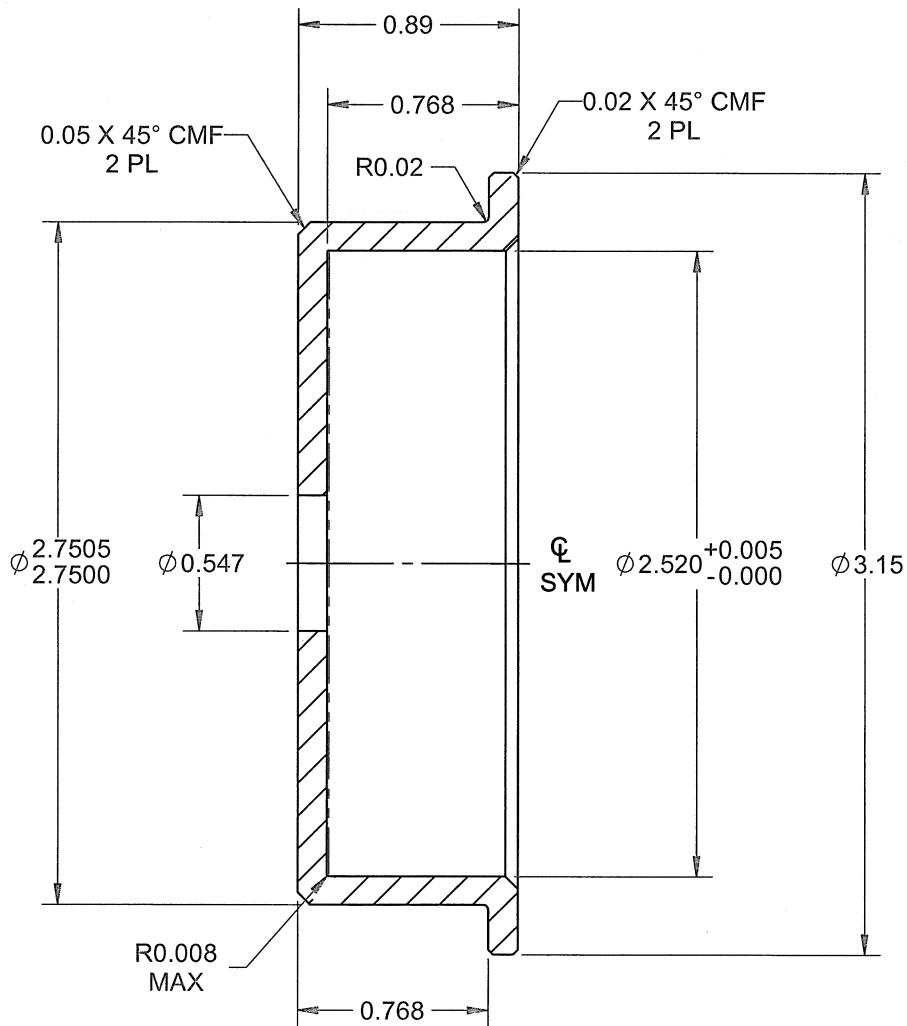
NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A

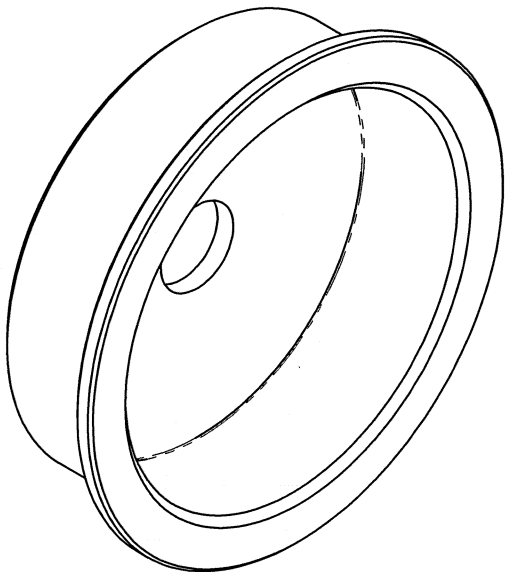
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	PK	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6230G00131-8G	SHEET 12 OF 13
APPROVED	VM	TITLE	SCALE
DATE 2/4/2019		MAIN ROTOR PITCH CONTROL LINK ADJUSTMENT TOOL	NTS
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RBW6230G00131-8G-12 CAP SLEEVE



SECTION G-G



- NOTES:
1) MATERIAL: NYLON 6
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PK	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6230G00131-8G	SHEET 13 OF 13
APPROVED	<i>Vog</i>	TITLE	SCALE
DATE 2/4/2019		MAIN ROTOR PITCH CONTROL LINK ADJUSTMENT TOOL	NTS
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